

Work Order ID 87214

87214

Page 1

July-11-12 10:32:01 AM

Item ID: D412-698-023

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener, LH/RH

Start Date: 7/10/12 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

***ST**

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

DAS 1E

12/06/09

MLJ 12-8-8
(4)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4x

12-8-7

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 1E

12/06/09

(+4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87214***87214***

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July-11-12 10:32:01 AM

Item ID: D412-698-023 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Automatic Door Opener, LH/RH
Start Date: 7/10/12 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10</u>								
	PPP Rev: <u>B</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/8/12

MLJ 12/08/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

July-11-12 10:32:00 AM

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Work Order ID: 87214

Parent Item: D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 7/10/12

Required Date: 8/03/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-12 JLM
IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD516L Washer	NAS1149D0516J	Purchased	No			120	Each	0.0000	2	114797	8P		
D3552-11 Door Prop		Manufactured	No			120	Each	21.0000	4	8P	8P		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		21							
				80345		9							
				83589		12							
D3594-043 Floor Doubler Assembly, LH		Manufactured	No			120	Each	6.0000	4x	8P	8P		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST233B		6							
				78539		6							
D3594-044 Floor Doubler Assembly, RH		Manufactured	No			120	Each	5.0000	4x	8P	8P		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST233B		5							
				78538		5							
D3594-5 Door Doubler		Manufactured	No			120	Each	12.0000	4x	8P	8P		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		-2							
				80404		12							
				ST234A		14							
D3622-1 Ball Stud		Manufactured	No			120	Each	18.0000	2	8P 12-8-7	8P		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST058		18							
				82072		18							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

July-11-12 10:32:01 AM

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Work Order ID: 87214

Parent Item: D412-698-023

Start Date: 7/10/12

Required Date: 8/03/12

Parent Item Name: Automatic Door Opener, LH/RH

Start Qty: 4.00

Required Qty: 4.00

MS20426AD4-4

Purchased

No

120

Each

3,012.0000

Rivet

Location

Loc Qty

Loc Code

GA

2864

121090

2864

ST317

148

121068

148

MS21073LS

nut plate

Purchased

No

120

Each

28.0000

Location

Loc Qty

Loc Code

ST303

28

120986

8

121444

20

2 8 171349 SP 12-8-7 4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E
Date: 08.05.01